





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D37647 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 11.10.07  
11-871 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/10/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
28 Sept 2011	110	Tried to fix feed and speed that was causing vibration on tool Co with caused on part to be scrap. <del>R-1. Program error</del> LOA	Q57042 11/09/28	Will ask to fix program. Scrap + Destroy qty x1 + Replace M <u>117933</u>	FK 11/09/28	28 11.9.28	Q57042 11/09/28	11/09/29
				→ Program to be fixed.			Q57042 11/09/28	11/09/29
								

NOTE: Date &amp; initial all entries



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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 74065**

Page 3

Wednesday, September 21, 2011 10:00:23 A

Item ID: D3764-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg Fitting

Start Date: 9/22/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Identify as per dwg &amp; Stock Location

243

0.00

Memo

0.00

Packaging

11/9/29 [Signature]

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/10/3 [Signature]  
MF 11-09-29

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 21, 2011 10:00:20 AM

Page 1

Work Order ID: 74065

Parent Item: D3764-1

Parent Item Name: Back Leg Fitting



Start Date: 9/22/2011

Required Date: 10/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No			100	f	8.6577	0.25	1.052632			



6061-T6 Bar 1.50 x 2.00



11.9.27

Location

MAT010

114608

117933 ✓

Loc Qty

8.65768

0.05768

8.6

Loc Code

1.4

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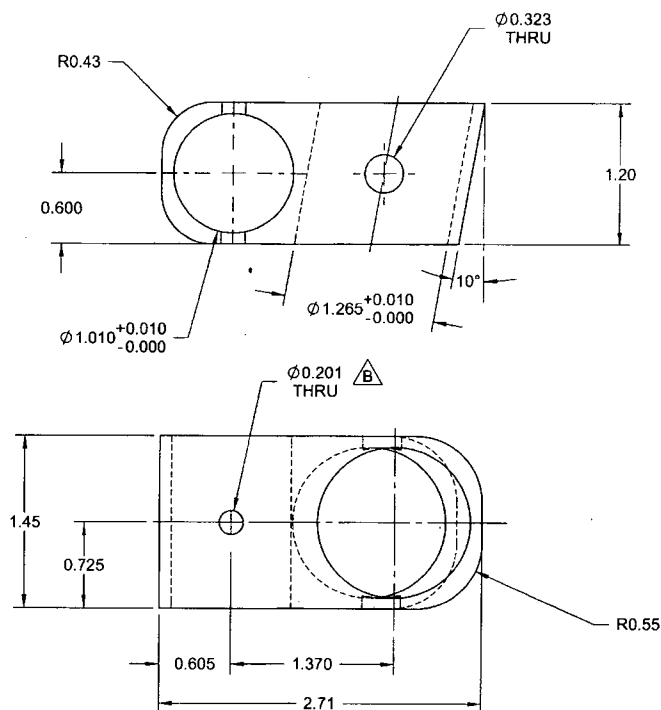
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

**NOTE:** Date & initial all entries



### **D3764-1 BACK LEG FITTING**

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.		DESCRIPTION	BY DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3764</b> REV. B SHEET 1 OF 1  TITLE <b>BACK LEG FITTING</b> SCALE NTSS	
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.10	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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